

Date: Monday, 3/26/2007 3:23:19 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG
Job Number	: 31485B		
Estimate Number	: 10841		
P.O. Number	: <u>N/A</u>	Part Number	: D22493
This Issue	: 3/26/2007 S.O. No. : <u>N/A</u>	Drawing Number	: D2249 REV. E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <u>N/A</u> Type : SMALL /MED FAB	Drawing Revision	: E
Previous Run	: 31031B	Material	: <u>N/A</u>
Written By	: <u>[Signature]</u>	Due Date	: 4/10/2007
Checked & Approved By	: <u>[Signature]</u>	Qty:	4 Um: Each
Comment	: Est: D 05.02.04 Added Step 9 KJ/RF Est Rev:E Now On Waterjet 07-03-08 JLM		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 .063 Sheet



Comment: Qty.: 0.1470 sf(s)/Unit Total: 0.5880 sf(s)

304/316 .063 Sheet

Batch: M103961

SAD 07/04/14

(4)

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2249

Dwg Rev: EProg Rev: E

2-Deburr if necessary

[Signature] 07/04/20
 SAD 07/04/14

(4)
 (4)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/04/14

(4)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

MS 07/04/15

(4)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Form as per Dwg D2249

FL 07/04/24

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: RD Date: 9/04/25
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/26/2007 3:23:20 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 31485B

Part Number: D22493

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10/04/24 (4)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 521

07/4/25 (4)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/04/25 (4)

Job Completion



07/04/25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

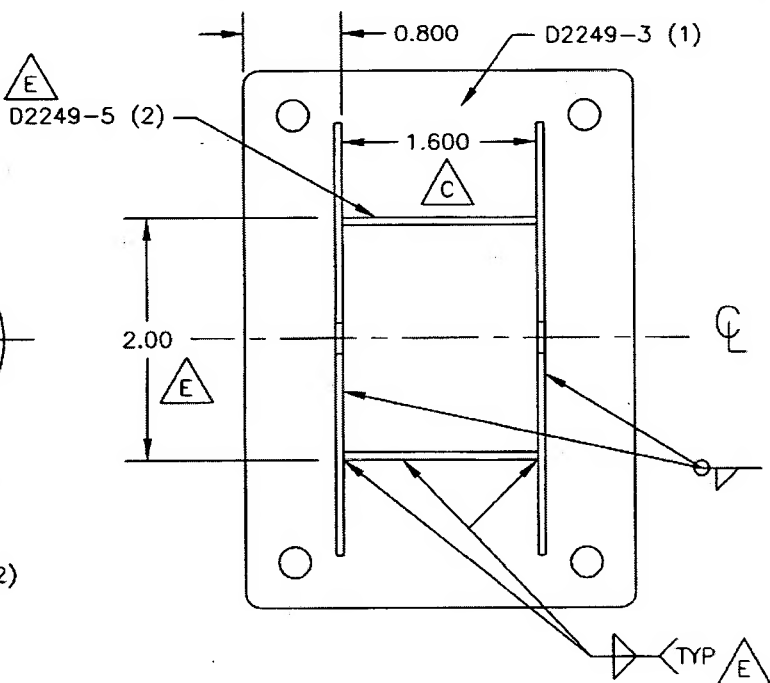
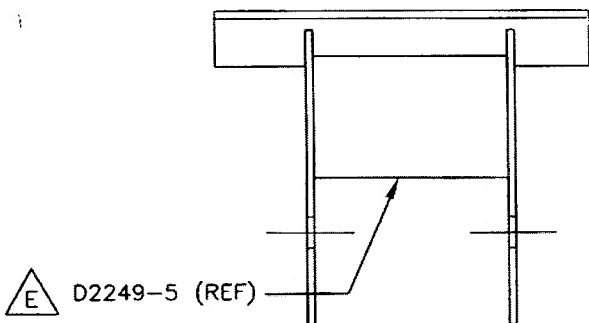
NOTE: Date & initial all entries

DART



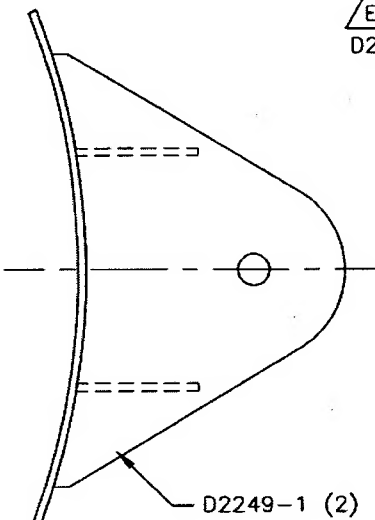
RELEASED
99.10.12 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
AE	RF	DRAWING NO.	REV. E
KE	RF	D2249	SHEET 1 OF 4
DATE	TITLE	SCALE	
99.09.20	FITTING	NTS	
A	94.06.20	NEW ISSUE	
B	95.11.30	DIMENSION CHANGE	
C	95.12.14	DIMENSION CHANGE	
D	98.04.30	Ø0.261 WAS Ø0.257 (TSR A179) REMOVED DUPLICATE DIMENSIONS	
E	99.09.20	ADDED GUSSET	



D2249-041 ASSEMBLY

MATERIAL: AISI 304/316 SS, 0.063 THICK
WELD PER DART QSI 004
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE SPECIFIED



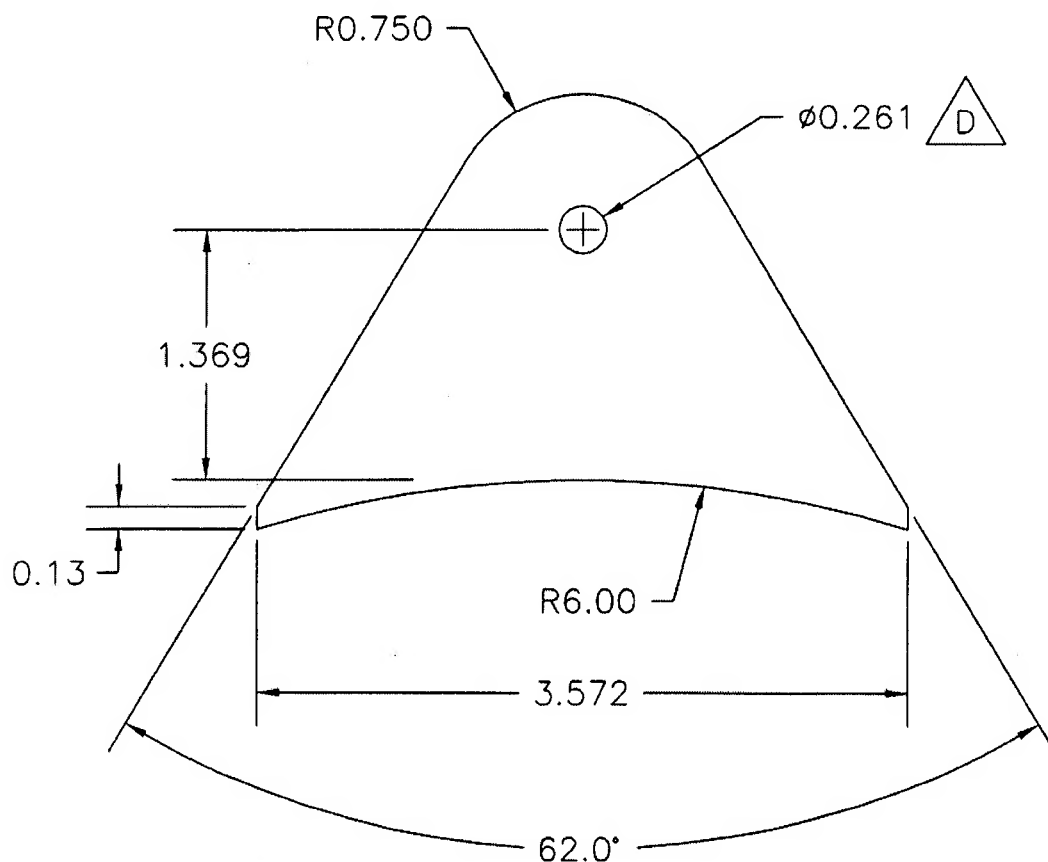
SHOP COPY
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WITHOUT NOTICE

WORK ORDER
NO. 314850



DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2249	REV. E SHEET 2 OF 4
DATE 99.09.20		TITLE FITTING	SCALE 1:1

RELEASED
99.10.12 *KE*



D2249-1 LUG

MATERIAL: AISI 304/316 SS 0.063 THICK

ALL DIMENSIONS ARE IN INCHES

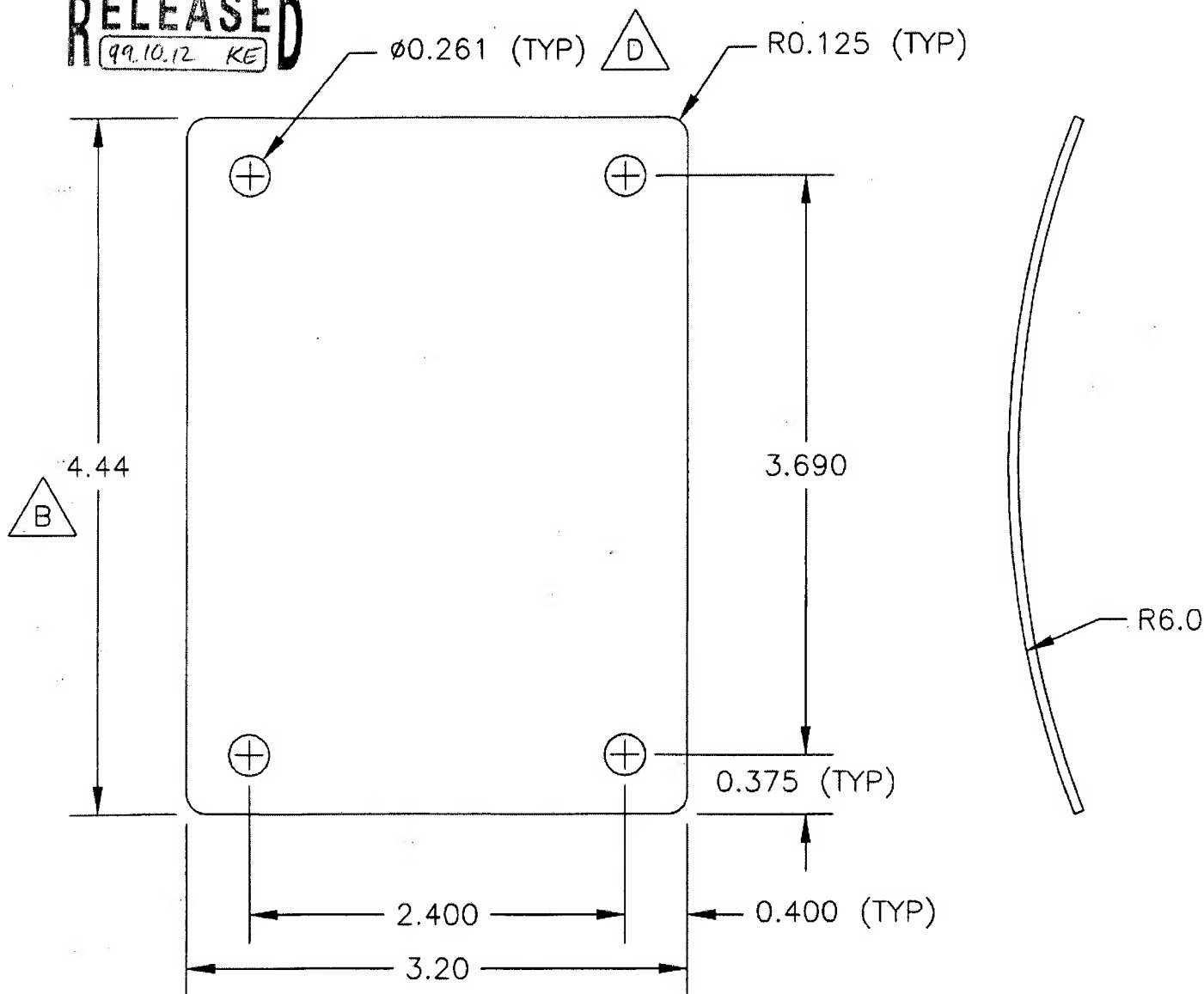
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WITHOUT NOTICE
WORK ORDER
NO. 31485B



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CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2249	REV. E SHEET 3 OF 4
DATE 99.09.20		TITLE FITTING	SCALE 1:1

RELEASED
99.10.12 KE



FLAT PATTERN

D2249-3 BASE PLATE

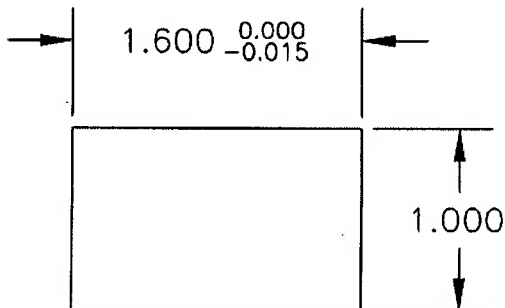
MATERIAL: AISI 304/316 SS 0.063 THICK
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WITHOUT NOTICE
WORK ORDER
NO. 31485B



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CHECKED <i>KE</i>	APPROVED <i>RF</i>	DRAWING NO. D2249	REV. E SHEET 4 OF 4
DATE 99.09.20		TITLE FITTING	SCALE 1:1

RELEASED
49.10.12 KE



D2249-5 GUSSET

MATERIAL: AISI 304/316 SS 0.063 THICK

ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WITHOUT NOTICE
WORK ORDER
NO. **31485B**

DART AEROSPACE LTD		Work Order: 31485B
Description: LUG		Part Number: D2249-3
Inspection Dwg: D2249 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	4.40	+/- 0.030	4.415	✓		Vern	
B	2.400	+/- 0.010	2.406	✓		Vern	
C	3.20	+/- 0.030	3.21	✓		Vern	
D	0.400	+/- 0.010	0.405	✓		Vern	
E	0.375	+/- 0.010	0.379	✓		Vern	
F	3.690	+/- 0.010	3.694	✓		Vern	
G	Ø 0.261	+0.006 -0.001	Ø 0.262	✓		Vern	
H	0.063	+/- 0.010	0.058	✓		Vern	
I							
J							
K							
L							
M							
N							
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P							
Q							
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T							
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V							
W							
X							
Y							

Measured by: SAY	Audited by: MB	Prototype Approval:	N/A
Date: 07/04/14	Date: 07/04/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	